

Work Order ID 63739

Friday, November 12, 2010 8:29:13 AM

Page 1

Item ID: D3943-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Handle Extension

Start Date: 11/12/2010 Start Qty: 5.00

Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-11-12 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3943

C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3943

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

MAT NOT PULLED

B10-11-17

(6)

B10-11-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____




NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries






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Revision ID:					Stop	
Item Name:	Handle Extension					
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Required Date:	11/19/2010	Req'd Qty:	5.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		8010118					
130  HAAS 1 HAAS CNC vertical machine #1	Memo MILL AS PER DWG AND FOLIO FA915 FOLIO REV: <u>AA</u> DWG REV: <u>C</u> 2-MILL DIMPLE USING 3/8" BALL MANUALLY	0.00 0.00		ask 10/12/02		6	0		
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		10/12/02					

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Page 3

Item ID: D3943-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Handle Extension

Start Date: 11/12/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Powdercoat

Powder Coating

Hybrid safety Yellow 4.3.5.12

M116329

0.00

Memo

0.00

Start Time: 10:55

Oven Temperature: 300

Finish Time: 10:05

6 11-01-27

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

11/14/20 6

170



Packaging

Packaging

Identify as per dwg & Stock Location: 1350

Memo

0.00

0.00

11/14/20 6

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Required Date: 11/19/2010 Req'd Qty: 5.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/01/31

NF

11-01-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Friday, November 12, 2010 8:29:19 AM

Page 1

Work Order ID: 63739



Parent Item: D3943-3



Parent Item Name: Handle Extension

Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: Est Rev:A New Issue 09-06-03 JLM Verified By:EC IPP Rev:B as per
dwg REV.C DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010B0.500X03.000		Purchased	No			100	f	0.0000	1.26	6.3	7.6		
1010-1025 BAR.500"x3.00"													



10-11-17

115686

115686

(6)

PER ATTACHED, PART M1010B0.500X03.000

ACCEPTABLE, MATERIAL IS MUCH STRONGER THAN 1010 STEEL. *[Signature]*

M4130NB0.500X03.000

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ITEM No.	QTY -041	QTY -051	QTY -053	PART NUMBER	DESCRIPTION	PREFERRED SUPPLIER
1	X			D3943-041	GROUND HANDLING CRANK ASSEMBLY	
5	1			D3943-051	HANDLE ASSEMBLY	
6	1		X	D3943-053	CHAIN ASSEMBLY	
11		1		D3943-1	HANDLE	M/F HANDLE FROM DIS-ASSEMBLED ITEM 39
12	1			D3943-3	HANDLE EXTENSION	
13		1		D3943-5	PLATE	
14		2		D3943-7	STUD	
15			1	D3943-9	CHAIN	USE CHAIN SUPPLIED WITH ITEM 39
21	1			D2690-4	LANYARD	
22	1			D3585-1	SET SCREW	
23	1			D3949-041	REMOVE BEFORE FLIGHT FLAG	
24			1	D3954-5	CHAIN LUG	
25	1			D3954-7	RATCHET LUG	
26			1	D3954-9	GWT CHAIN PIN	
31	1			AN5-11A	BOLT	
32	1			AN960-516	WASHER	
33	1			MS21042L5	NUT	
39	1			8143919	LEVER CHAIN HOIST (POWER FIST)	PRINCESS AUTO / 4000 lbs CAPACITY
41	1			S-1475	SPRING	REID SUPPLY
42	1			3408A59	BALL PLUNGER	McMASTER CARR
43	1			HX-15	SOCKET HEAD CAP SCREW 1/4-20 UNC X 0.75 LG	HASKINS
44	1			HX-16	SOCKET HEAD CAP SCREW 1/4-20 UNC X 1.0 LG	HASKINS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63739
PA/10-11-12

RELEASED
2010-10-18
AWP

C	RMV FINISH -041 (ZN A8-2), ADD NEW FINISH -051/-053/-1/-3 (A8-3/-4/-5), ADD CALIBRATION (A8-2), (1) HX-16 WAS HX-15 (B3-1, C3-1), PAR 10-001	CP	10.01.26
B	SHT 1 PL, ITEM 31 WAS AN4-10A, ITEM 32 WAS AN960-416, ITEM 33 WAS MS21042-4, ITEM 43 WAS 0.75 LG. SHEETS 2 - 5 NOTES: FINISH FOR ALL COMPONENTS NOW YELLOW SPRAY PAINT.	AJS	09.10.15
A	NEW ISSUE	AJS	09.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DSTOW / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>AWP</i>		
CHECKED	<i>AWP</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>AWP</i>	D3943	SHEET 1 OF 5
APPROVED	<i>AWP</i>	TITLE	SCALE
DE APPR.	N/A	GROSS WEIGHT TOW CRANK ASSY	NTS
DATE	10.01.26	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

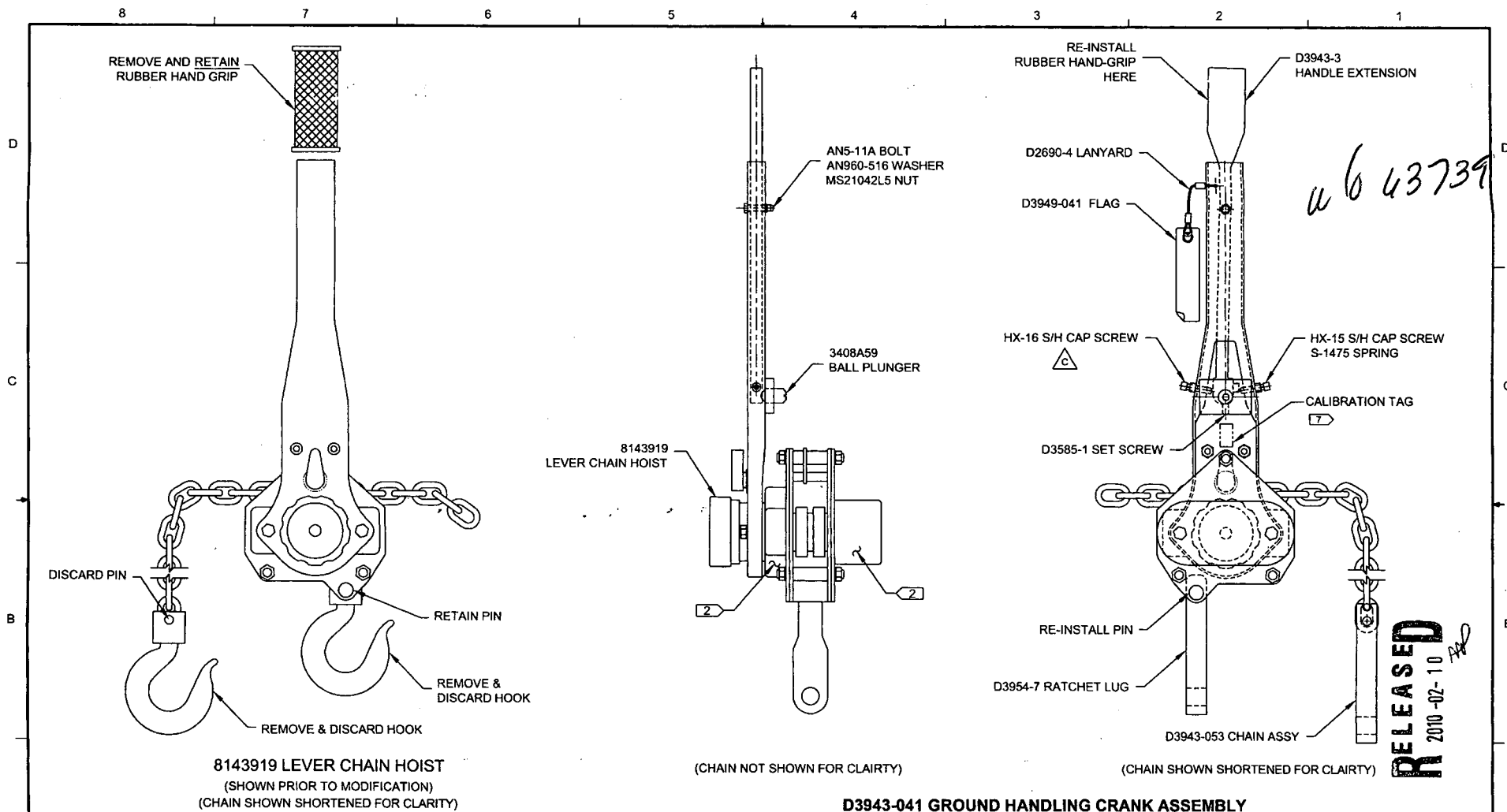
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____





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NOTE: Date & initial all entries



NOTES -041:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3943-041" USING FINE POINT PERMANENT INK MARKER
- 7) CALIBRATION TAG PER DART QSI 008 4.4 (ZN C1-2)

DESIGN	DSTOW / AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3943	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.	M/A	GROSS WEIGHT TOW CRANK ASSY	NTS
DATE	10.01.26	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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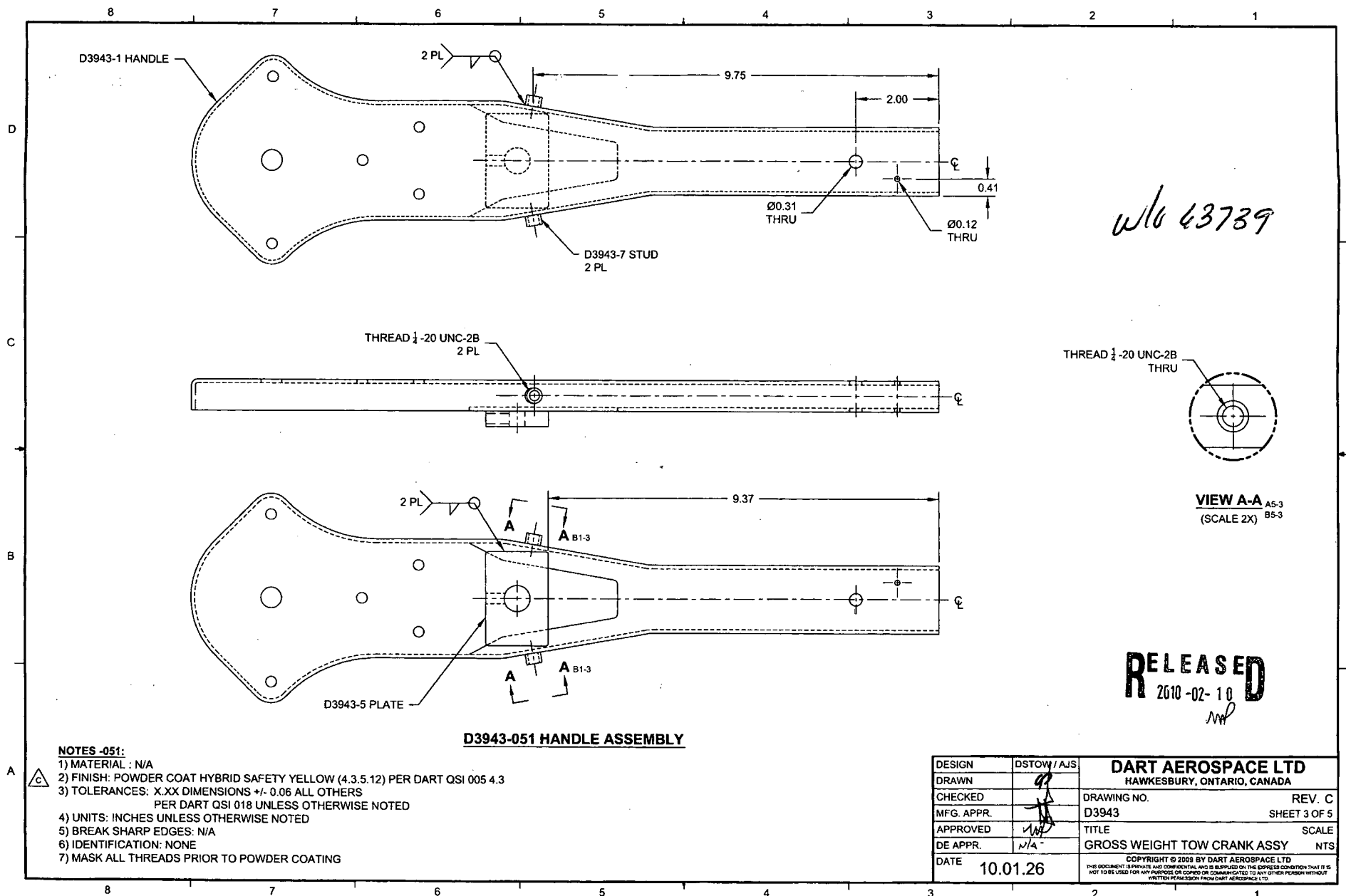
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

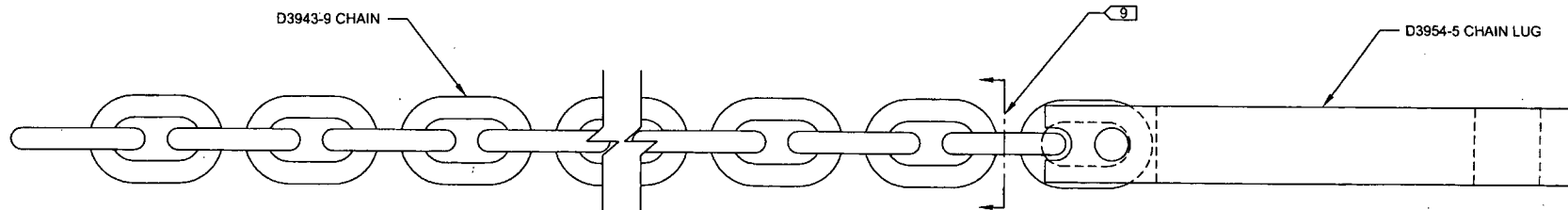
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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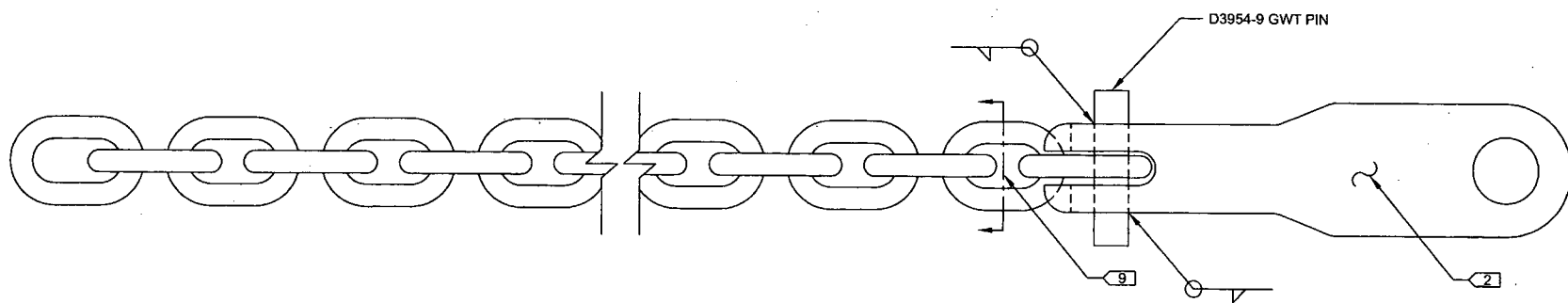
8 7 6 5 4 3 2 1

D



u6 43739

C



D3943-053 CHAIN ASSEMBLY

RELEASED
2010-02-10

A

NOTES -053:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER QSI 004
- 9) MASK CHAIN FROM THIS POINT ON PRIOR TO POWDER COATING

DESIGN	DSTOW/AJS	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3943	REV. C
MFG. APPR.		TITLE	SHEET 4 OF 5
APPROVED		GROSS WEIGHT TOW CRANK ASSY	SCALE
DE APPR.			NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

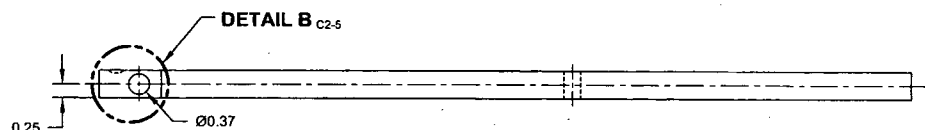
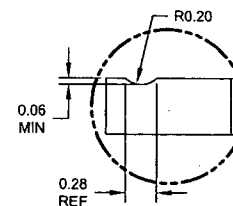
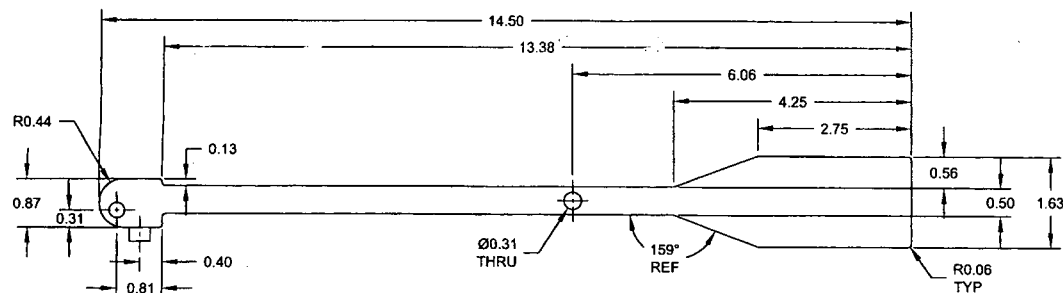
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

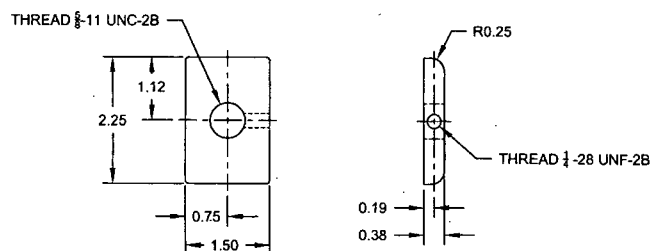
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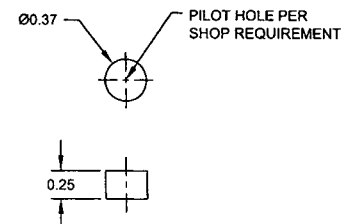
8 7 6 5 4 3 2 1



D3943-3 HANDLE EXTENSION



D3943-5 PLATE



D3943-7 STUD
(SCALE 2X)

NOTES -11/-13:

- 1) MATERIAL -3 & -5: MILD STEEL, SHEET
AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-S
- OR: MILD STEEL, BAR
AISI 1010-1025 OR ASTM A36/A366/A569/A570
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-B
- 7: MILD STEEL, ROUND BAR
AISI 1018-1025
PER MIL-S-7097
REF DART SPEC M1018-R

- 2) FINISH -3: POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3
-5 & -7: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE

RELEASED
2010-07-10

DESIGN	DSTOW/AJS	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3943	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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List Lots

Page 1 of 1

Wednesday, November 17, 2010 4:04:21 PM

Criteria : All Items All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
M174B0.250X4.000 17-4 SS Bar .250 X 4.00	Main Warehouse MAT	115686	10/5/2010	7.2300			
				Total:	7.2300		
M4130NB0.500X03.000 4130 Bar 0.500 x 3.00	Main Warehouse MAT	115686	10/7/2010	4.7250			
				Total:	4.7250		